

# Work Order ID 72468

Tuesday, July 26, 2011 9:07:50 AM



Page 1

Item ID: D4131-1

Accept



Setup Start



Revision ID:

Item Name: Front Plate

Stop



Start Date: 7/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-26 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4131

A U/R

see z44240 email

0.00

100



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.050

1-Cut as per Dwg

Dwg Rev: U/R

Prog Rev: U/R

2-Deburr if necessary

B14-8-9



110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-8-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72468**

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Item ID: D4131-1

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Revision ID:

Stop



Item Name: Front Plate

Start Date: 7/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

0.00 *8/10/11*

QC

Memo

Quality Control

*(12)*

130

Identify as per dwg & Stock Location: *131*

0.00



0.00

Packaging

Memo

Packaging

*8/11/11 (12)*

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

*OK 11/08/11**11-08-11 (12)*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Tuesday, July 26, 2011 9:07:55 AM

Work Order ID: 72468



Parent Item: D4131-1



Parent Item Name: Front Plate



Start Date: 7/26/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	237.6550	0.1807	1.902105	2.5		
											B11-8-9		

Location

Loc Qty

Loc Code

MAT020

85.655

113062

13.655

116135

3

116979

69

MAT021

152

118217

152

114979

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

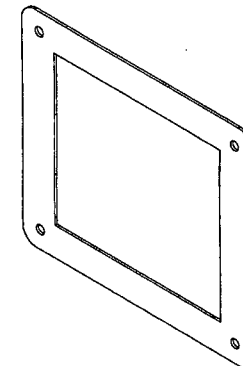
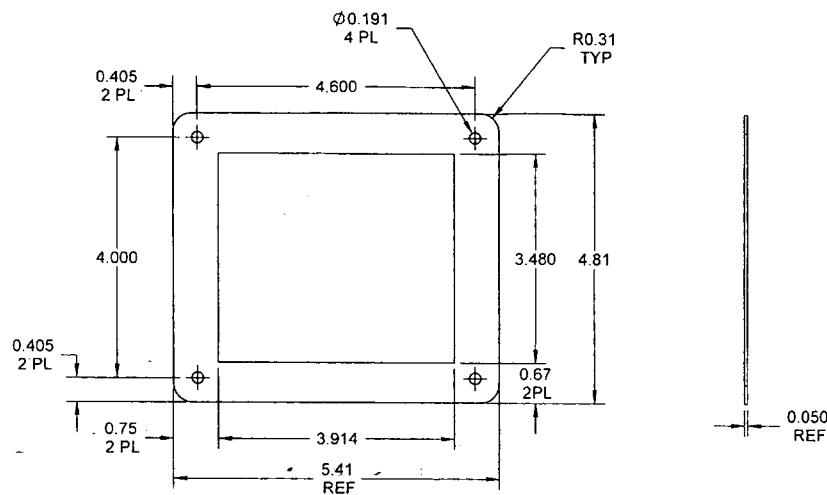
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72468

UNDER REVIEW  
11/15/2011

11-07-24

**D4131-1 FRONT PLATE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

**RELEASED**  
2010-09-23  
WPD

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	10	DRAWING NO.	REV. A
MFG. APPR.	10	<b>D4131</b>	SHEET 4 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	<b>MANIFOLD ASSEMBLY</b>	NTS
DATE	10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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**NOTE:** Date & initial all entries

**Linda Lacelle**

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** July 22, 2011 1:00 PM  
**To:** 'Linda Lacelle'; 'Roberto Fuentes'  
**Cc:** Mike Petsche; 'Kim Johnston'  
**Subject:** RE: Under Review - D4092, D4093, D4153, D4074 and D4131

Linda,

as discussed:

- a) D4092/D4093 should not be manufactured as is
- b) There are changes coming on D4153 and D4131, but it is acceptable to manufacture and release parts that are made per per D4153 Rev A and D4131 Rev A
- c) All D4074-X parts must be manufactured per D4074 Rev B ... There is no change to D4074-1/-5 but changes are required to D4074-3/-7. D4074 Rev B should arrive in Hawkesbury today.

Hope this clarifies the situation ... Sorry for any confusion.

David

**From:** Linda Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** July-22-11 7:16 AM  
**To:** 'Roberto Fuentes'  
**Cc:** dshepherd@dartaero.com  
**Subject:** RE: Under Review - D4092, D4093, D4153, D4074 and D4131

have kits to ship next week, and more the week after, when is 4074, 4153 and 4131 all going to be released??

**From:** Roberto Fuentes [mailto:rfuentes@dartaero.com]  
**Sent:** July 20, 2011 11:45 AM  
**To:** Linda Lacelle  
**Cc:** 'Stocker, Alan'; 'Beckett, Bill'; 'Golden, Brigitte'; 'Lavoie, Chantal'; 'Provencal, Chris'; 'Campbell, Daniel'; 'Duval, David'; 'Shepherd, David'; 'Charbonneau, Eric'; 'Downing, Eric'; 'Siemens, Harvey'; 'Jean-Francois Sauve'; 'Menard, Jean-Luc'; 'Johnston, Kim'; 'Fauteux, Melanie'; 'Petsche, Mike'; 'Willems, Sian'; 'Bedford, Sue'; 'Sheldon, Susanne'; 'Kerr, Cathy'; Marc Bellavance  
**Subject:** Under Review - D4092, D4093, D4153, D4074 and D4131

Hi everyone,

D4092, D4093, D4453, D4074 and D4131 drawings are now under review per attached form.

Thanks,  
Roberto